

Work Order ID 76458

November-15-11 8:04:02 AM

76458

Page 2

Item ID: D407-802-011

Accept

N900040100

Setup Start

NS1

Work Order ID 76458

November-15-11 8:04:02 AM

76458

Page 1

Item ID: D407-802-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crew Door Opener Installation, LH

Stop

NS2

Start Date: 15/11/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/11/15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

IIN-D407-802-1

A

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D407-802-011

0.00

0.00

DAS 16

17/10/03

CHG001

CHG 052

12-9-27

105

105

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

2x

12-9-27

110

110

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

DAS 16

17/10/03

72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE

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NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE

Picklist Print

November-15-11 8:04:06 AM

Page 1

Work Order ID: 76458

76458

Parent Item: D407-802-011

D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.02 per revA DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15 *D3552-15* Door Prop		Manufactured	No			105	Each	11.0000	2				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST272				11					
					65119			11					
D3622-5 *D3622-5* Ball Stud		Manufactured	No			105	Each	12.0000	4				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST070				12					
					65087			12					
D4106-1 *D4106-1* Sill Doublbr, LH		Manufactured	No			105	Each	4.0000	2				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST127				4					
					64331			4					
D4106-3 *D4106-3* Crew Door Doublbr, LH		Manufactured	No			105	Each	4.0000	2				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST127				4					
					64333			4					



**

B881001K SP
B. 79271 IR, C



**

B80406 SP



**

B80699 SP



**

B79342 SP
12-9-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 76458

76458

Parent Item: D407-802-011

D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

D4106-5

Manufactured No

105 Each

10.0000

D4106-5

Spacer, Sill Doublber



2

B80700 sp.

Location

Loc Qty

Loc Code

ST127

10

64335

2

64341

8

D4106-7

Manufactured No

105 Each

3.0000

D4106-7

Template



2

B79172 sp.

Location

Loc Qty

Loc Code

ST127

3

64336

3

CR3523-4-02

Purchased No

105 Each

450.0000

CR3523-4-02

RIVET



52

m120873.

Location

Loc Qty

Loc Code

ST314

450

116391

100

116893

3

116915

1

117946

46

117978

200

118686

100

CR3523-4-4

Purchased No

105 Each

14.0000

CR3523-4-4

Rivet



8

m119717 sp

12-9-27.

Location

Loc Qty

Loc Code

ST314

14

115768

14

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 76458

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

76458

D407-802-011

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

CR3523-4-5

Purchased

No

105

Each

74.0000

CR3523-4-5

Rivet

**

3*

6

Location

Loc Qty

Loc Code

ST314

74

117423

74

105

Each

104.0000

CR3523-4-6

Purchased

No

CR3523-4-6

Rivet

**

8

16

Location

Loc Qty

Loc Code

ST314

104

115768

15

116606

89

105

Each

103.0000

CR3523-4-07

Purchased

No

CR3523-4-07

RIVET

**

7

14

Location

Loc Qty

Loc Code

ST314

103

116606

100

17768

3

105

Each

5,242.000

MS20426AD4-5

Purchased

No

MS20426AD4-5

Rivet

**

4

8

Location

Loc Qty

Loc Code

MEZZ

165

6733

165

ST317

5077

6874

5077

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November-15-11 8:04:07 AM

Work Order ID: 76458

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

76458

D407-802-011

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

MS21073LS

Purchased

No

105

Each

73.0000

MS210731 5

nut plate

**

2 4

m120986 SP

Location

Loc Qty

Loc Code

ST302

73

117395

73

105

Each

281.0000

NAS1149C0532R

Purchased

No

NAS1149C.0532R

WASHER

**

6 12

m122441 SP

Location

Loc Qty

Loc Code

ST297

281

116373

1

116513

53

118384

227

105

Each

370.0000

NAS1149C0563R

Purchased

No

NAS1149C.0563R

Washer

**

6 12

SP 12-9-27

Location

Loc Qty

Loc Code

ST297

370

116391

182

117460

188

12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

5.1 D407-802-011/-012 Crew Door Opener Kits

Qty -011	Qty -012	Part Number	Description
1	1	D407-802-011	CREW DOOR OPENER KIT, LH
1	1	D407-802-012	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1	1	D4106-1	SILL DOUBLER, LH
1	1	D4106-2	SILL DOUBLER, RH
1	1	D4106-3	CREW DOOR DOUBLER, LH
1	1	D4106-4	CREW DOOR DOUBLER, RH
1	1	D4106-5	SPACER, SILL DOUBLER
1	1	D4106-7	TEMPLATE
26	26	CR3523-4-2	RIVET
4	4	CR3523-4-4	RIVET
3	3	CR3523-4-5	RIVET
8	8	CR3523-4-6	RIVET
7	7	CR3523-4-7	RIVET
4	4	MS20426AD4-5	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

Change Record

PAGE 1 OF 1

Part Number: D407-802-011

Description: CREW DOOR OPENER, LH

[illegible]